

Date: Thursday, 02/04/2009 2:29:10 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : DOUBLER
 Job Number : 46896
 Estimate Number : 13832
 P.O. Number :
 This Issue : 02/04/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D38941
 First Issue : / / Type : SMALL /MED FAB Drawing Number : D3894 REV.A
 Drawing Revision : A
 Previous Run :
 Material :
 Due Date : 14/04/2009 Qty: 6 Um: Each
 Written By :
 Checked & Approved By : JUD 09.04.03
 Comment : Est Rev:A 09.03.06 new issue EC verified by:dd

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S050 6061-T6 .050 Sheet



Comment: Qty.: 0.0211 sf(s)/Unit Total : 0.1266 sf(s)

6061-T6 ALUM .050 Sheet

BATCH: 104186

IB 9-4-23

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3894

Dwg Rev: A

Prog Rev: A

IB 9-4-23

2- Deburr if necessary

8/30/09/04/24

(18)

(18)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



IB 9-4-23

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

8/30/09/04/24 (18)

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST. 139C

8/30/09/04/28 (18)

4b Alu etch + Abodure per dstoes

4c

QC3

11

09-04-27

(18)

158

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09/04/2018	4	Permanant change	MDP	09/04/27	18		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: DOUBLER

Job Number: 46896

Part Number: D38941

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/08 [Signature]

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-04-28

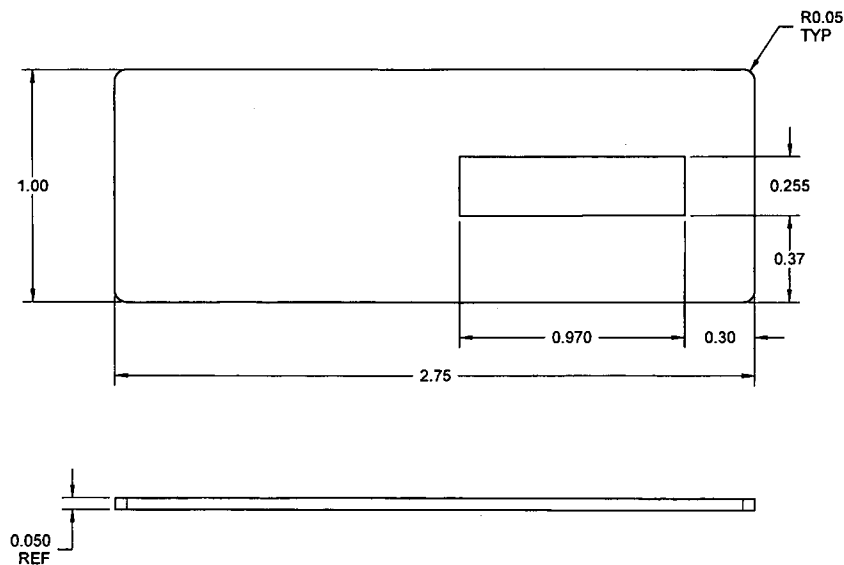
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3894-1 SWITCH PLATE

RELEASED
09/02/10

A		NEW ISSUE		09.02.03	
REV.		DESCRIPTION		BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3894 TITLE SWITCH PLATE		REV. A	
DRAWN				SHEET 1 OF 1	
CHECKED				SCALE	
MFG. APPR.				NTS	
APPROVED					
DE APPR.		DATE 09.02.03		COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.050 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC M6061T6S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3894-1" & B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.04 lbs

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WITHOUT PREJUDICE
11/08/10